

Date: Saturday, 04/04/2009 4:51:44 PM
User: Jean-Luc Menard

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET |
| Job Number : 46928 | |
| Estimate Number : 11481 | |
| P.O. Number : | Part Number : D31462 |
| This Issue : 04/04/2009 S.O. No. : | Drawing Number : D3146 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 26710 | Material : |
| Written By : <i>[Signature]</i> | Due Date : 11/04/2009 Qty: 8 Um: Each |
| Checked & Approved By : <i>[Signature]</i> | |
| Comment : Est A 04.04.28 New issue KJ/JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

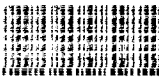
| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B1250X04500 | 6061 T6 Bar 1.25 X 4.50 |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.2931 f(s)/Unit Total : 2.3444 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick
(M6061T6B1.250x04.500)
Identify for D3146-1
Batch: *M109401*

SP 09/04/04

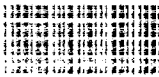
| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
Cut blanks: 4.500" x 1.250" x 3.100" long Bar

SP 09/04/04

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|

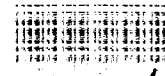
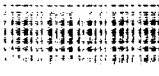


Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per 1.0 and 2.0 and 3.0
Identify as per 1.0

M.A 09/04/07 SP 09/04/06

⑧

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 09/04/07 SP 09/04/06

⑧



Comment: SECOND CHECK

SP 09/04/08


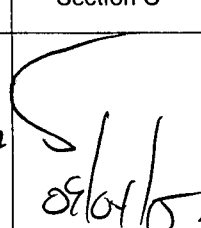

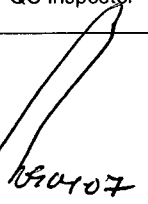
⑧



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3146-2 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/15

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: <u>46928</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|--|---|-----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09/04/07 | 3.0 | I came in this morning and the part was already in the jaws for facing operation. The part was not sitting properly in the jaws. 1 part scrap. 125 dimension is .105 R.C: Operator error in clamping. |  | Scrap & destroy Replace Qty 1 B <u>109401</u> | H.A 09/04/07 |  |  |  |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46928

Part Number: D31462

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE #1
Deburr and Tumble

Handwritten: A S

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Handwritten: Umo/ FL

Handwritten: (X8) 09/04/09

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M110939

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 1:45
320°
2:15

Handwritten: BR 09-04-14

Handwritten: (8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: FL 09/04/14

Handwritten: (X)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

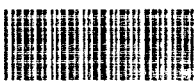
Handwritten: S 09/05/15

Handwritten: (X5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 68

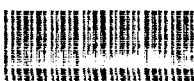
Handwritten: SS 09/04/15

Handwritten: (X8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/04/15

12.0



Handwritten: MK 09-04-15

| | | | |
|-------------------------------------|--|---------------------|----------------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Bracket | | Part Number: | D3146-2 |
| Inspection Dwg: D3146 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

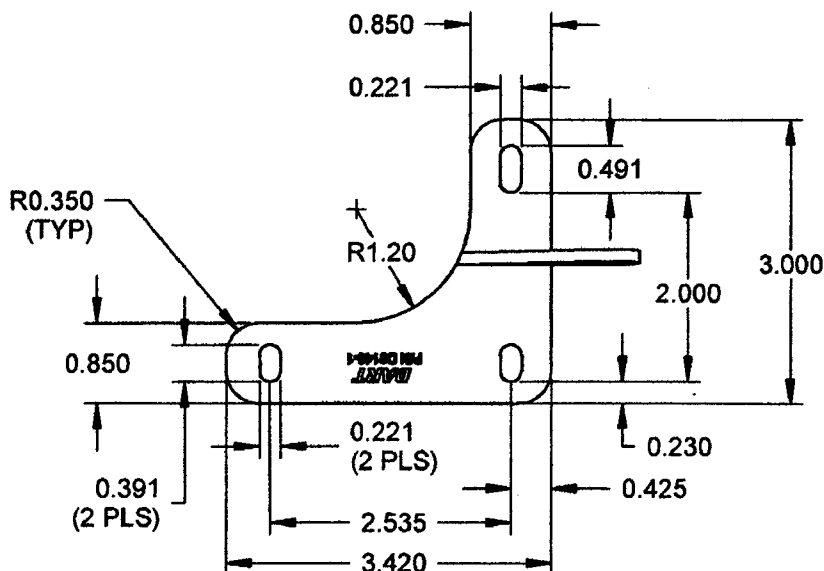
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 3.000 | +/-0.010 | 3.001 | ✓ | | | |
| 2.000 | +/-0.010 | 2.000 | ✓ | | | |
| 0.230 | +/-0.010 | .232 | ✓ | | | |
| 0.425 | +/-0.010 | .424 | ✓ | | | |
| 3.420 | +/-0.010 | 3.423 | ✓ | | | |
| 2.535 | +/-0.010 | 2.535 | ✓ | | | |
| 0.221 | +/-0.010 | .220 | ✓ | | | |
| 0.391 | +/-0.010 | .386 | ✓ | | | |
| 0.221 | +/-0.010 | .220 | ✓ | | | |
| 0.850 | +/-0.010 | .852 | ✓ | | | |
| R0.350 | +/-0.010 | .350 | ✓ | | | |
| 0.850 | +/-0.010 | .852 | ✓ | | | |
| 0.221 | +/-0.010 | .219 | ✓ | | | |
| 0.491 | +/-0.010 | .486 | ✓ | | | |
| 0.125 | +/-0.010 | .125 | ✓ | | | |
| 1.025 | +/-0.010 | 1.034 | ✓ | | | |
| R0.375 | +/-0.010 | R.375 | ✓ | | | |
| 28° | +/-0.5° | 28° | ✓ | | | |
| 0.276 | +/-0.010 | .282 | ✓ | | | |
| 0.925 | +/-0.010 | .919 | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| 4.345 | +/-0.010 | 4.342 | ✓ | | | |
| 0.125 | +/-0.010 | .125 | ✓ | | | |
| 93° | +/-0.5° | 93° | ✓ | | | |
| R0.125 | +/-0.010 | .125 | ✓ | | | |
| Grind Dimension | N/A | | | | | |

| | | | |
|----------------------------------|--------------------------------|---------------------|-----|
| Inspected by: <i>[Signature]</i> | Audited by: <i>[Signature]</i> | Prototype Approval: | N/A |
| Date: 09/04/06 | Date: 09/04/08 | Date: | N/A |

| Rev | Date | Change | Revised by |
|-----|----------|-----------------------------------|------------|
| A | 04.06.22 | New Issue | KJ/JLM |
| B | 07.06.13 | Dimensions updated per DWG Rev. C | KJ/JLM |



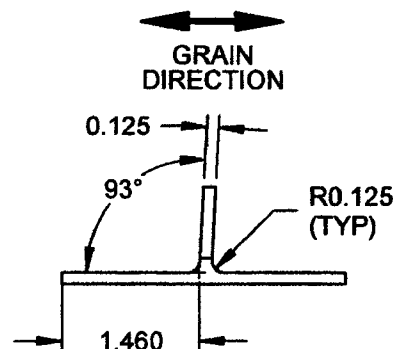
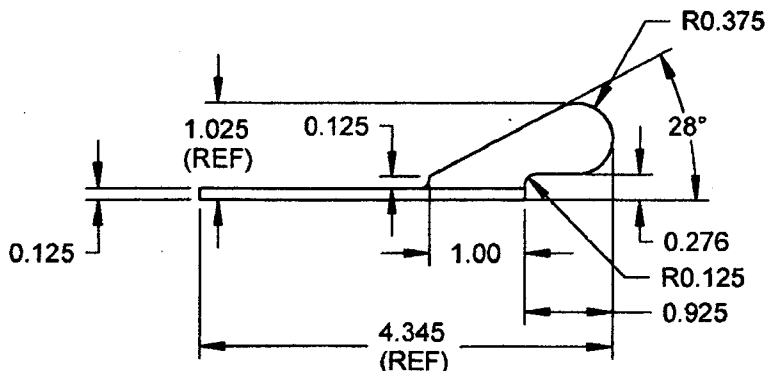
| | | | |
|------------------|------------------|---|------------------------|
| DESIGN # | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED # | DRAWING NO. D3146 | REV. B SHEET 1 OF 2 |
| DATE 07.03.28 | TITLE BRACKET | | SCALE 1:2 |
| REV | DATE | DESCRIPTION | |
| A | 02.04.25 | NEW ISSUE | |
| B | 07.03.28 | ADD -4: ROTATED LOGO AND P/N | |



RELEASED
07.06.04



W/O 46928



**D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)**

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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